

539

DART AEROSPACE LTD	Work Order:	24206
Description: Doubler	Part Number:	D3286-1
Dwg: D3286 Rev. A	Qty:	100
Ref:		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler Dwg not required	AP	05/09/07	10
2	PG	Order (2) D3286-1 per (1) skidtube assembly Issue P/O: 2008659 Email or Ship DXF file to vendor Laser Cut flat pattern per Dwg D3286 Material release note is required	AP	05/09/15	100
3	RG	Receive and Inspect for transit damage Enure material release note is attached	DL	05/10/17	98
4	QC6	Inspect dimensions as per Dwg D3286.	SB	05/10/19	98
5	GA	Deburr	SAD	05/10/23	98
6	GB	Form as per Dwg D3286	SB	05/10/24	98
7	QC5	Inspect work to Step 6	DL	05-10-24	98
8	ST	Identify and Stock	CL	05/10/25	98
9	AC	Cost / part: 2.94	SAC	05-10-26	98
10	DC	Close W/O 3 96 Inspect Level 21	DL	05/10/26	98

Rev	Date	Change	Revised By	Approved
A	04.07.14	New issue	KJ/JLM	

RELEASED

Jul 07.07.14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: 17 Date: 05/18/20

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Sep 02, 2005
09:01 am

Work Order No : 0024206
Project Name : D3286-1
Project For : WK539
Work Order Type : Main
Main WO Number :
House Part Number : D3286-1
Description : Doubler
Manufactured : Yes
Amount Req'd : 10
Amount Done : 0
Start Date : 09-01-05
Est Finish Date : 09-29-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00



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(09) 235 8069 / 235 3535 Wairuku
Fax: (09) 375 8959

TEST CERTIFICATE

Ref: 5078/21768

CUSTOMER	Wilkinson	P50128DI003	SPECIFICATION	ASTMA1008 CS Type A	CERTIFICATE No	TC109561
CUSTOMER O/N	90-21N-540		PRODUCT	CRA WIRE COIL	PAGE	1 of 1
MILL O/N	471159		DIMENSIONS	0.055" x 48" x Coil	DATE	23 April 2005

PACK NUMBER	HEAT No	CHEMICAL COMPOSITION PERCENT															MECHANICAL TESTS (TEST SPECIFICATION - ASTMA370)							
		C	SI	Mn	P	S	Cu	Ni	Cr	Mo	V	Nb	Ti	Al	B	N2	CE()	BEND	YIELD	T.S.	%ELONG	HARDNESS	r	LENGTH
		x100			x1000												x10000	x100	180°				G.L.=	HRB
R9-457097-00	640590	4	TR	20	13	17	12	17	20	1	8	1	1					Good				46		1562
R9-457098-00	640590	4	TR	20	13	17	12	17	20	1	8	1	1					Good				46		1483
R9-457099-00	640590	4	TR	20	13	17	12	17	20	1	8	1	1					Good				46		1562
R9-457100-00	640590	4	TR	20	13	17	12	17	20	1	8	1	1					Good				46		1496
R9-457101-00	640590	4	TR	20	13	17	12	17	20	1	8	1	1					Good				47		1562
R9-457102-00	640590	4	TR	20	13	17	12	17	20	1	8	1	1					Good				47		1555

YIELD	GAUGE LENGTH (G.L.)				PLASTIC STRAIN RATIO (r)				IMPACT TEST	(C)=5mm x 5mm	CARBON EQUIVALENT VALUE (CE)			
(A)=0.2% PROOF STRESS	(A)=200mm	(C)=80mm	(E)=2"		(A)=r0	(C)=r45			(A)=10mm x 10mm	(D)=2.5mm x 10mm	(A)=C+Mn/6			(C)=C+Mn/6+Si/24
(B)=LOWER YIELD STRESS	(B)=50mm	(D)=5.65 x So	(F)=8"		(B)=r90	(D)=(r0+r90+2r45)/4			(B)=7.5mm x 10mm	(E)=5mm x 10mm	(B)=C+Mn/6+(Cr+V+Mo)/5+(Cu+Ni)/15			(D)=

WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS BEEN TESTED AND INSPECTED WITH SATISFACTORY RESULTS IN ACCORDANCE WITH THE REQUIREMENTS OF THE ABOVE SPECIFICATION

APPROVED *Satish Misra*
QC METALLURGIST

16 ga crms



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TEST CERTIFICATE

Ref: 5078/21768

CUSTOMER	Wilkinson	P5012801003														SPECIFICATION				ASTMA1908 CS Type A				CERTIFICATE No		TC109561	
CUSTOMER O/N	90-21N-540										PRODUCT				CRA WIDE COIL				PAGE		1 of 1						
MILL O/N	471159										DIMENSIONS				0.055" x 48" x Coil				DATE		23 April 2005						
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		C	Si	Mn	P	S	Cu	Ni	Cr	Mo	V	Nb	Ti	Al	B	N2	CE()	BEND	YIELD	T.S.	%ELONG	HARDNESS	r	LENGTH			
		x100			x1000											x10000		x100		180°				G.L.=	HRB	()	(feet)
R9-457097-00	640590	4	TR	20	13	17	12	17	20	1	8	1	1					Good				46		1562			
R9-457098-00	640590	4	TR	20	13	17	12	17	20	1	8	1	1					Good				46		1483			
R9-457099-00	640590	4	TR	20	13	17	12	17	20	1	8	1	1					Good				46		1562			
R9-457100-00	640590	4	TR	20	13	17	12	17	20	1	8	1	1					Good				46		1496			
R9-457101-00	640590	4	TR	20	13	17	12	17	20	1	8	1	1					Good				47		1562			
R9-457102-00	640590	4	TR	20	13	17	12	17	20	1	8	1	1					Good				47		1555			

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16 ga crms